

Work Order ID 151982

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Item ID: D119-796-151 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: FWD Crosstube Installation with Step (no hardware)
Start Date: 10/28/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/23/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: **DAS 21** Date: **OCT 17 2016** Tooling: Date: Run Start ***NR1***
QC: **9-89** Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D119-796-151	D								
110	Document Control	0.00							DAS 21 9-89
110									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D119-796-151 chg 004								
120	Pick Kit	0.00							DAS 41 9-89
120	Packaging								
Packaging	Memo	0.00							17-2-3
Packaging									
130	Crosstubes	0.00							DAS 41 9-89
130									
Crosstubes	Memo	0.11							17-2-3
Crosstubes	1- Install step and clamp with the proper position per dwg D119-796-151								
	Torque all clamps to 50 IN-LBS max.								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC		0.00							
Quality Control	Memo ***RE-CHECK TORQUE ON CLAMP AS PER DWG.*** ***VERIFY BY <u>151982</u> BATCH # TO MATCH W/O ***VERIFY BY <u>151982</u> PART # TO MATCH W/O <u>151982</u>								DAS 38 3-89 FEB 13 2017
150	Packaging	0.00							
150									
Packaging		0.00							
Packaging	Memo Identify and pack for shipping as per PPP D119-796-151 Au 1								DAS 41 9-89 17-2-3
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC		0.02							
Quality Control	Memo								DAS 21 9-89 FEB 13 2017

Picklist Print

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Work Order ID: 151982

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Parent Item: D119-796-151

D119-796-151

Parent Item Name: FWD Crosstube Installation with Step (no hardware)

Start Date: 10/28/2016

Required Date: 11/23/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP
REV:B 14.11.19 AS PER REV.C DD VERF:JLM IPP REV:C
14.12.09 AS PER REV.PC6 DD VERF:JLM IPP REV:D 15-02-11
AS PER REV D JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-796-141		Manufactured	No				Each	0.0000		1		DAS 41 9-89	17-1-16
D119-796-141					152307				**	1			
FWD Crosstube Installation without Step (no hardware)													
D5123-3		Manufactured	No				Each	126.0000		4		DAS 41 9-89	17-1-16
D5123-3									**				
Clamp Cushion													

Location	Loc Qty	Loc Code
LG055	126	
149113	16	
149671	12	
150315	48	
151097	50	

D5149-041		Manufactured	No				Each	6.0000		2		DAS 41 9-89	17-2-3
D5149-041									**				
Fwd Step Base Assembly													

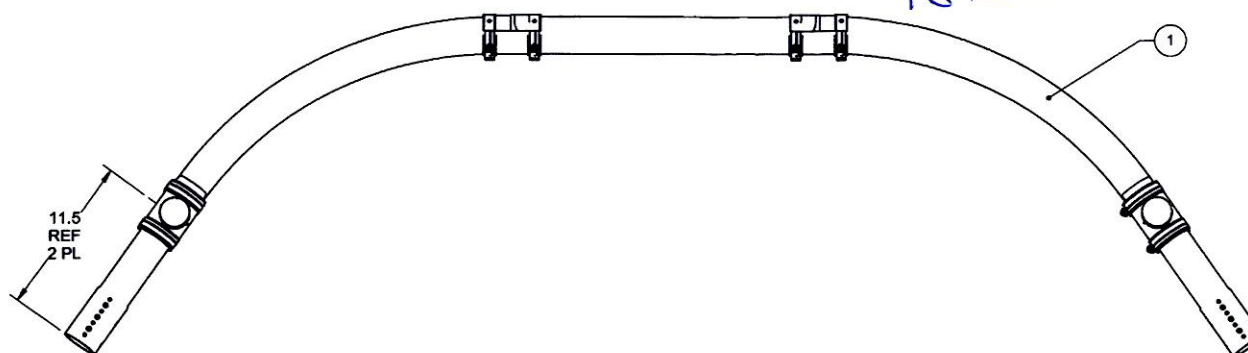
Location	Loc Qty	Loc Code
LG055	6	
148204	6	

MS21920-22		Purchased	No				Each	82.0000		4		DAS 41 9-89	17-1-16
MS21920-22									**				
Clamp													

Location	Loc Qty	Loc Code
LG050	82	
M135544	32	
M135603	50	

ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
1	1	D119-796-141	XTUBE ASSY (AW119 MKII FWD)
2	4	D5123-3	CUSHION
3	2	D5149-041	FWD STEP ASSEMBLY
4	4	MS21920-22	CLAMP

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151982 MJS
161017



D119-796-151 XTUBE ASSY (AW119 MKII FWD)

RELEASED

2015 FEB 09

ECN 15-516

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 19.87 lbs
- 8) TORQUE MS21920-22 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE

D	D5123-3 CLAMP CUSHION WAS D5123-9 CLAMP CUSHION, MS21920-22 WAS -24.	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D5149-043 WAS D5149-041, AN4C6A WAS AN4C10A, D2274 WAS D5153-1	AP	14.11.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	DB	DRAWING NO.	REV. D
MFG. APPR.	JLM	D119-796-151	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII FWD)	NTS
DATE	15.01.19	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	